

Date: Monday, 17/07/2006 2:58:34 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 27869		
Estimate Number	: 11167		
P.O. Number	: <u>N/A</u>	Part Number	: D32783
This Issue	: 17/07/2006 S.O. No. : <u>N/A</u>	Drawing Number	: D3278 REV B
Prsht Rev.	: <u>NC</u>	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 27869	Material	: <u>N/A</u>
Written By	: <u>SRR COMMENT Below</u>	Due Date	: 24/07/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	40 Um: Each
Comment	: Est. A 04.04.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDEL RINS0125X300 Black Delrin



Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.4448 sf(s)

Black Delrin

Use DT8685 Router Table.

Material: Black Delrin/UHMW 0.125" thick

(M-DEL RIN-S0.125x30.0)

Identify for D3278-3

Batch: M101687

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3278

Dwg Rev: BProg Rev: B

2-Deburr if necessary

SAD 05:08:08

40

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:08:08

40

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/08/11

40

Date: Monday, 17/07/2006 2:58:34 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27869

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'sink as per dwg D3278

2-Deburr

ml

PTO
Qty 35

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location *GA*

SB 06/08/17 *(33)*

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

D 06/08/18

Job Completion



U 06/08/18

Step 5: Found 40 pieces No Good.
Have 40 other pieces

ml
06/08/11

Scrap 8 pieces when c'sink
No replace ml 06/08/14

Step 5 3 part were scrap part were damaged | SB 06/08/17
see attached → ver: Approval

Date: Tuesday, 7/11/2006 1:05:54 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 27869		
Estimate Number	: 11167		
P.O. Number	:	Part Number	: D32783
This Issue	: 7/11/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3278 REV B
First Issue	: 11	Project Number	: N/A
Previous Run	:	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	: <u> </u>	Due Date	: 7/18/2006
Checked & Approved By	: <u> </u>	Qty:	40
Comment	: Est. A04.04.19 New issue KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MDELRLINS0125X300	Black Delrin
-----	-------------------	--------------



Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.4448 sf(s)
 Black Delrin
 Use DT8685 Router Table.
 Material: Black Delrin/UHMW 0.125" thick
 (M-DELRIN-S0.125x30.0)
 Identify for D3278-3
 Batch:

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 (1) blank makes (4) D3278-3
 Cut blanks: 1.98" x 9.145" x 0.125" thick.

3.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



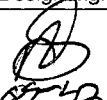
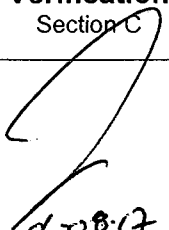

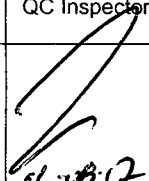

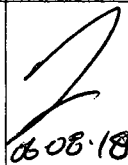
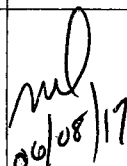
Comment: HARDHINGE COBRA
 Machine as per Folio FA404 and Dwg D3278
 Deburr
 Identify as D3278-3

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-17	5	3 parts scrap due to damage from the water jet	 06/08/17	destroy no replace.	SB 06/08/17	 06-08-17	 06-08-17	 06-08-17
06-08-18	2	40 parts holes oversized off water jet cutting . was over tolerance. Program error for hole size.		reduce off set to obtain proper hole size. destroy & replace Qty 40.	SAD 06-08-18	 06-08-18		 06-08-18
06-08-18	5	6 parts scrapped during C'sinking.		destroy no-replace.	 06/08/17			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/11/2006 1:05:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27869

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion:

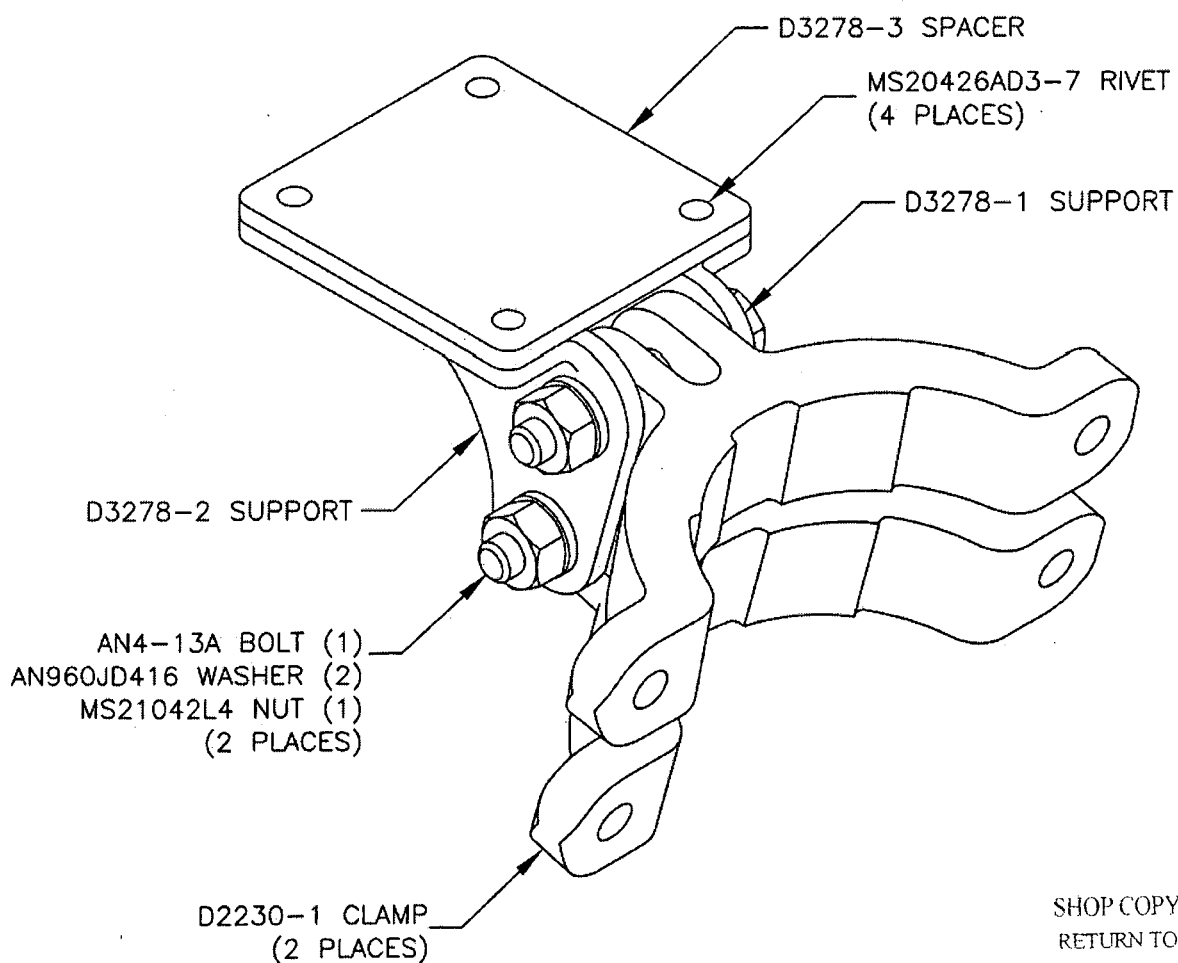




DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D3278	REV. B
					SHEET 1 OF 3
DATE	05.03.31	TITLE	SUPPORT ASSEMBLY	SCALE	NTS
A	04.03.03	NEW ISSUE			
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT			

RELEASED
05.04.04

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27869

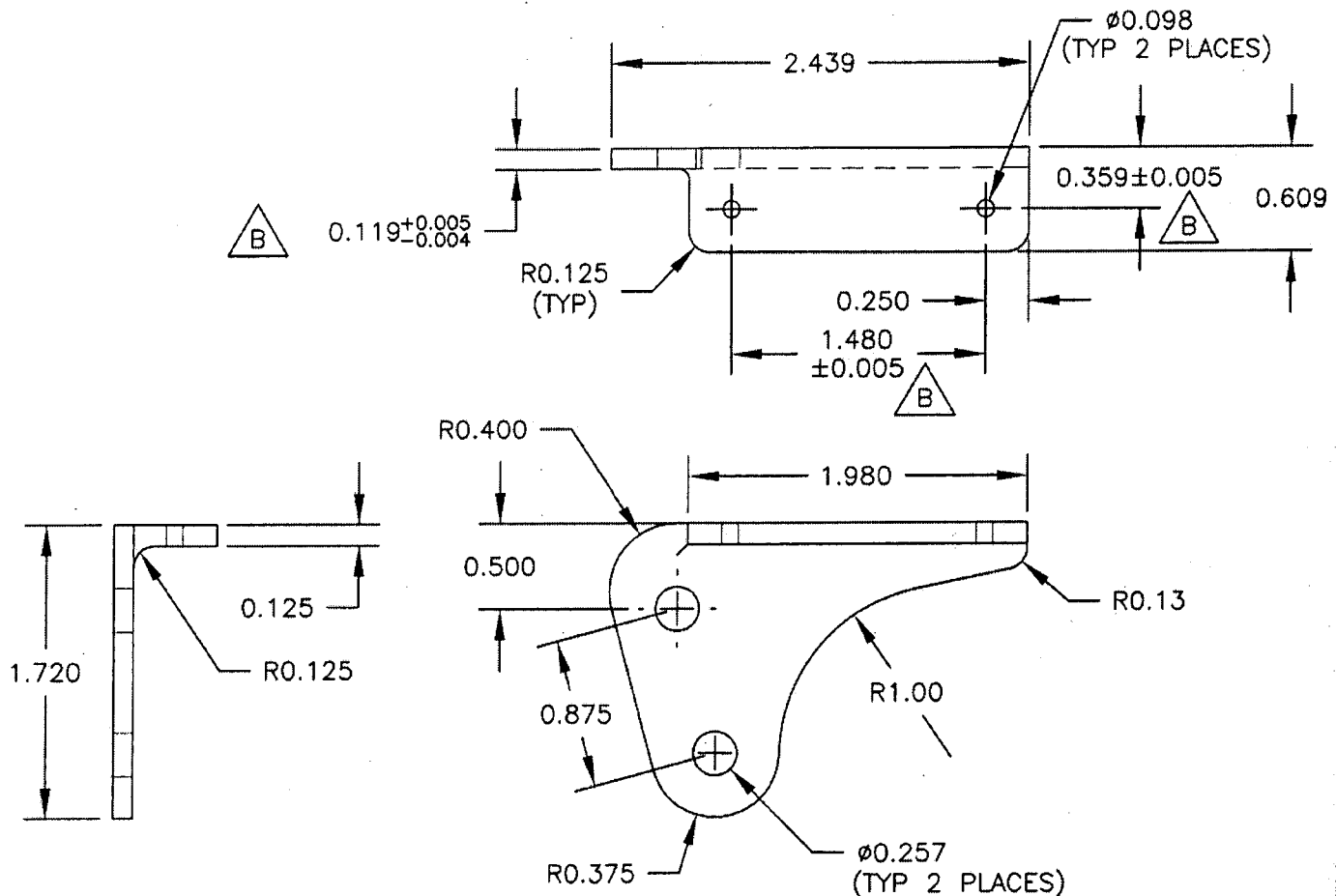
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 2 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED

05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27869

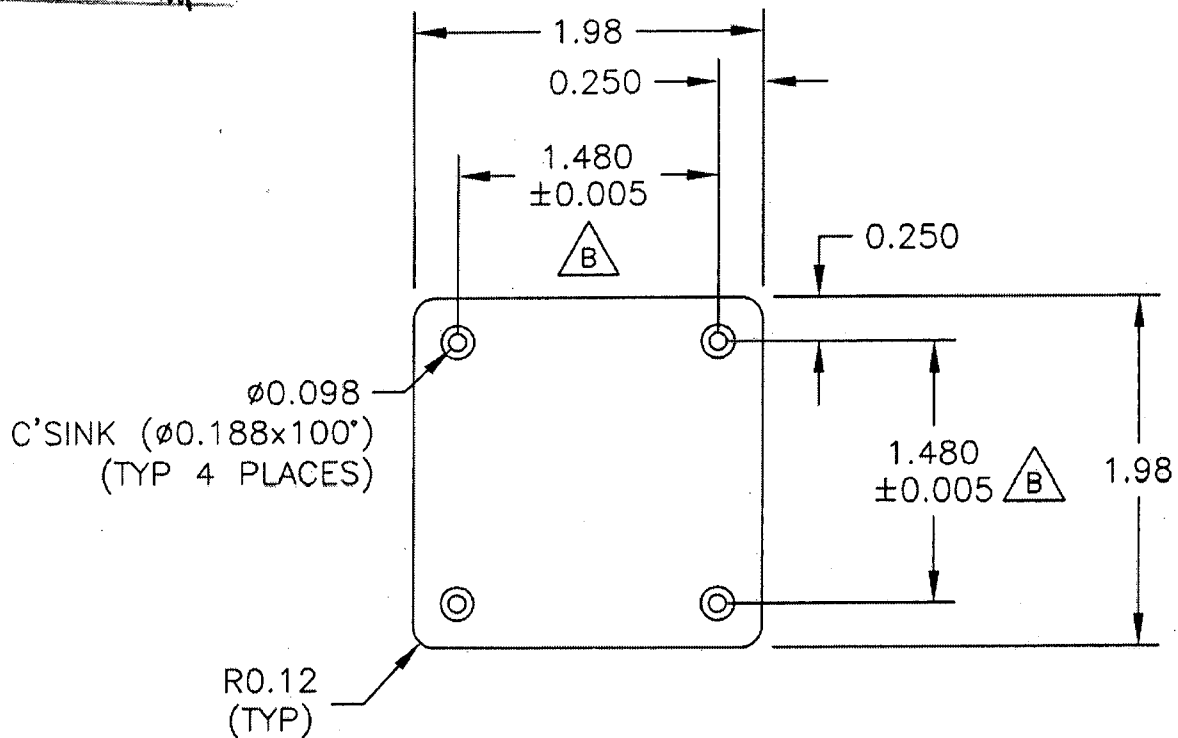
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
05.04.04 *[Signature]*



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-CY UNCONTROLLED COPY
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27869

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.